

Date: Tuesday, 2/26/2008 8:02:43 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BALL JOINT ROD END
Job Number : 37641	
Estimate Number : 12440	
P.O. Number :	Part Number : D35183
This Issue : 2/26/2008 S.O. No. :	Drawing Number : D3518 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / 1 Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 31684	Material :
Written By :	Due Date : 3/10/2008 Qty: 10 Um: Each
Checked & Approved By : <u>08 02 26</u>	
Comment : Est Rev. A New Issue 06-11-22 JLM	
est rev B rev b dwg 07.04.09 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	2458K14	rod end
-----	---------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 rod end

2.0	PG	PURCHASING
-----	----	------------



Comment: Issue P/O: 5796
 Purchase Part Number: 2458K14
 Supplier: Mc Master Carr
 Certificate of conformity is required

08/02/26

(10)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure certificate of conformity is attached

8/3/3

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

08/03/08 (10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: 606

8/3/3 50

(10x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 08/03/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:02:43 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BALL JOINT ROD END

Job Number: 37641

Part Number: D35183

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

2008/03/04

Job Completion



2008/3/04 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

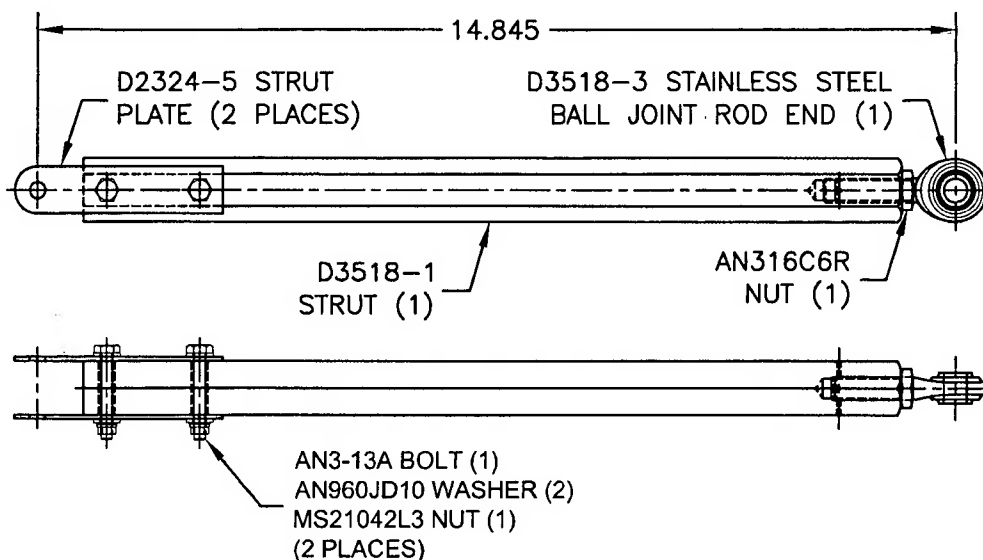
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 1 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:3
A	06.06.21	NEW ISSUE	
B	06.10.23	RE-DESIGN	



D3518-041 STRUT ASSEMBLY

QTY -041	Part Number	Description
X	D3518-041	STRUT ASSEMBLY
2	D2324-5	STRUT PLATE
1	D3518-1	STRUT
1	D3518-3	STAINLESS STEEL BALL JOINT ROD END
2	AN3-13A	BOLT
1	AN316C6R	NUT
4	AN960JD10	WASHER
2	MS21042L3	NUT

NOTES:

- 1) IDENTIFY WITH DART P/N "D3518-041" USING FINE POINT PERMANENT INK MARKER

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NO 37641

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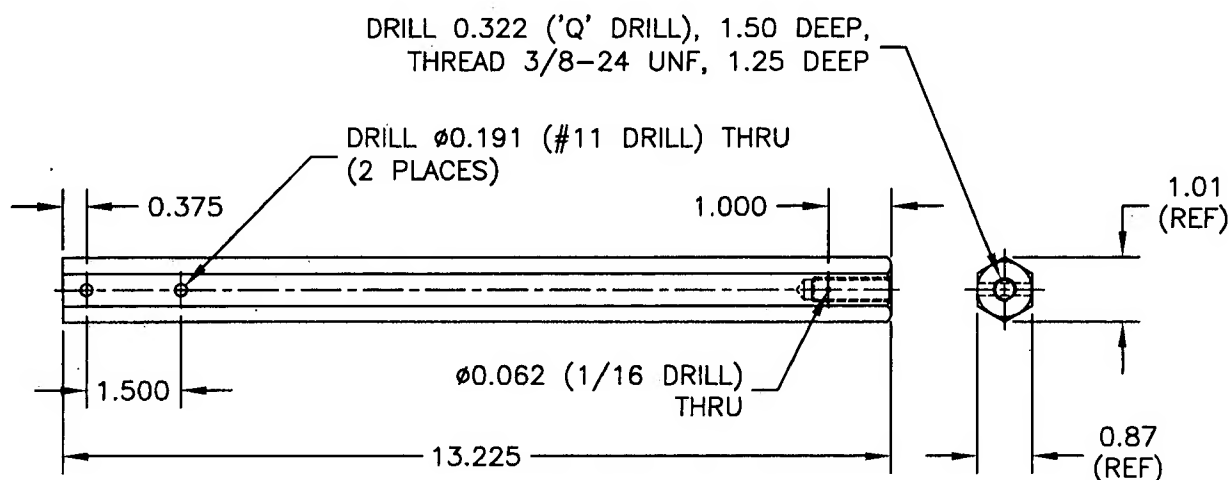
06.11.17 *[Signature]*

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CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D3518	REV. B SHEET 2 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:3



D3518-1 STRUT

NOTES:

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM HEX BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART MATERIAL SPEC M6061T6H0.875)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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06.11.17 *H*

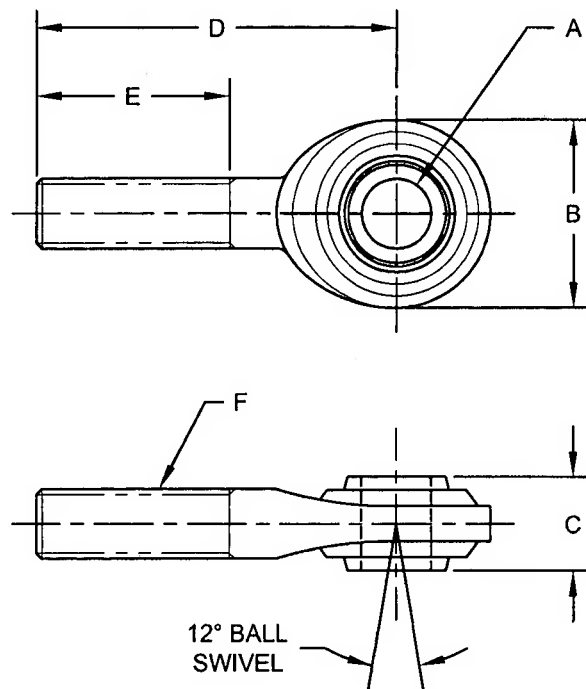
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DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 3 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:1

SPECIFICATION CONTROL DRAWING



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NO. 37641

DART P/N	A	B	C	D	E	F	LOAD*	POSSIBLE SUPPLIER
D3518-3	0.375	1.00	0.50	1.938	1.25	3/8-24 UNF, RH	4012	McMASTER-CARR, P/N 2458K14

* Indicated load is Static Radial Load Capacity in lbs

NOTES:

- 1) TYPE: MALE THREADED SHANK CARBON-FIBER-REINFORCED PLASTIC RACE BALL JOINT ROD END
- 2) MATERIAL: ZINC PLATED STEEL HOUSING BALL WITH PTFE LUBRICATED CARBON-FIBER-REINFORCED PLASTIC RACE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.11.17 *[Signature]*

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McMASTER-CARR®

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Aurora, OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
P000005796

Page 1 of 1

McMaster-Carr Number
6763675-02

02/27/2008

Line	Description	Ordered	Shipped
------	-------------	---------	---------

5	4146A93 1/2" Hex Shank Arbor for 1-5/16" to 2-9/16", Hole Cutter for Sheet Metal	1 Each	1
1	9504K17 Brass Shim Stock Roll, .004" Thick, 6" Width X 60" Length	3 Each	3
2	2458K14 Carbon-Fiber Race Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 4012 Pound Load Capacity	10 Each	10
3	8353T74 Pneumatic Wheel with One-Piece Rim, 18" X 5.9", center Hub, 1-1/4" Axle, Roller Bearing, 1590#cap	12 Each	7

3 - 54 - 13 **66 - 25** A93

1 EA

3 - 262

3 - 297

8 - 79

Shipped separately from our Chicago warehouse on 02/27

3	8353T74 Pneumatic Wheel with One-Piece Rim, 18" X 5.9", center Hub, 1-1/4" Axle, Roller Bearing, 1590#cap	12 Each	5
4	4146A38 Hole Cutter for Sheet Metal, 2-1/4" Diameter, Tin Coated	1 Each	1

Dart Aerospace Ltd

Assembly
Area

88

Cycle

30

Shelf

801

Documents

4

EXP



110 lbs
4 lines

EW1BSP38
02/27/2008
10:48/11:02
282



8005839689192